



Dart Aerospace Ltd.
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647.0112
Job Sheet 187045



Part No: 647.0112

Job Qty: 20 ea

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.0100 REV.B SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		12/14/18	0.00	0.79	Waterjet - Flow		18/12/01
110	QC	20 pcs		12/14/18	0.00	0.00	QC2 Waterjet-1		18/12/01
120	QC	20 pcs		12/14/18	0.00	0.00	QC8-1		38
130	Brake NC	20 pcs		12/14/18	0.00	0.89	Brake NC 1		38
140	QC	20 pcs		12/14/18	0.00	0.00	QC5		38
150	SprayPaint	20 pcs		12/14/18	0.00	0.47	Spray Paint		18-12-2018
160	QC	20 pcs		12/14/18	0.00	0.00	QC14		DEC 24 2018
170	Packaging	20 pcs		12/14/18	0.00	0.00	Packaging3-1		DEC 24 2018
180	QC21-SA	20 Ea		12/14/18	0.00	0.00	QC21		DEC 27 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 130 - USE DT9834 FOR FORMING

150 - PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N PRIME AS PER DWG NOTE 6 BATCH: 5094268

170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	.6500 sf (.0325 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S14GA	1	54	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176		
2	Strut Bracket	0.191Inches + 0.005 - 0.001	0.196 0.190		
3	Strut Bracket	0.300Inches ± 0.030	0.330 0.270		
4	Strut Bracket	0.900Inches ± 0.030	0.930		

			0.870
5	Strut Bracket	0.350Inches $\pm$ 0.010	0.360 0.340
6	Strut Bracket	1.500Inches $\pm$ 0.030	1.530 1.470
7	Strut Bracket	1.006Inches $\pm$ 0.030	1.036 0.976
8	Strut Bracket	0.080Inches $\pm$ 0.010	0.090 0.070

Plex 11/27/18 8:48 AM Dart.lajeunesse.marie



Container No: S133711



Part: 647.0112
Job No: 187045
Serial No/Batch: S133711

Revision: B
Inspector:
Exp Date:
Instructions:

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Date: 12/02/18

